

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000663**Date Inspected:** 22-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89 Mock-Up**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 89 Meter Mock-Up, Corner Splice Plate, Plates SA24-3 and P913-3 weld #MUB-MA21F/J-12B was welded by Zhenhua Port Machinery Company (ZPMC) certified welder Dai Lu #048659 and the welding parameters recorded by this QA Inspector were, Amps 183, Volts 23.5, Travel Speed (T/S) 114mm/min. and the Temperature was 168c. The other section of this Corner Splice Plate, SA24-4 and P913-4 weld #MUB-MA21F/J-11B was welded by certified welded Wang Zhong Hua #053753 and the welding parameters recorded by this QA Inspector were, Amps 186, Volts 23.8, T/S 110 and the Temperature was 164c. The welding procedure utilized for both welders was WPS-B-T-3212-TC-U5b. A rod oven was being utilized to maintain the required temperature of the welding rods 9018M-H4R. The CWI present was Sha Zhi and the QC was Xu Jing Long.

Item-2 89 Meter Mock-Up Plate C. Plates MP511-1, MP512-1 & MP510-1 to MP507-1, MA23-1 & MP508-1. Plates being preheated for the welding of the root. Welding of the root is in progress.

**Summary of Conversations:**

There were no pertinent conversations pertaining to the project during this shift.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

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## WELDING INSPECTION REPORT

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for your project.

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**Inspected By:** Smith,David

Quality Assurance Inspector

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**Reviewed By:** Cochran,Jim

QA Reviewer